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D3641-1

Job Sheet 206702



Part No: D3641-1

Job Qty: 8 pcs

DAS
21
9-98

Part Name: Cover



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/20

Job Tracking No:

Due Date: 3/2/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D3641 REV C IPP Rev:A New Issue 07-07-20 JLM Verified By:EC IPP Rev:B ECN 1050 rev.b as per
dwg 08-01-10 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs			0.17	0.49	Waterjet - Flow		20/03/22
110	QC 2	6 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		20/03/22
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
QC 2 - 62									
QC 2 - 63									
QC 2 - 8									
QC 2 - 66									
QC 2 - 64									

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120 QC 8	6 pcs	0.00 0.00	QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 8 - 12	
			QC 8 - 14	
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
130 Small Fab - Brake NC - B4B	6 pcs	0.25 0.42	QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	APR 2 2 2020
140 QC 5	6 pcs	0.00 0.00	QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
130 Small Fab - Brake NC - B4B	6 pcs	0.25 0.42	QC 8 - 76	
			QC 8 - 61	
			Small Fab - Brake - 1 - B4B	
140 QC 5	6 pcs	0.00 0.00	Small Fab - Brake - 2 - B4B	
			Small Fab - Brake - 3 - B4B	APR 15 2020
			QC 5 - 10	
140 QC 5	6 pcs	0.00 0.00	QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
140 QC 5	6 pcs	0.00 0.00	QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
140 QC 5	6 pcs	0.00 0.00	QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
140 QC 5	6 pcs	0.00 0.00	QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
140 QC 5	6 pcs	0.00 0.00	QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
140 QC 5	6 pcs	0.00 0.00	QC 5 - 40	APR 15 2020
			QC 5 - 61	
			QC 5 - 81	
150 Handfinish - 1-1 Chemical-B4B	6 pcs	0.00 0.35	Handfinish - 1 - 1 - B4B	BEB 20-04-16
			Handfinish - 1 - 2 - B4B	

			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
160	QC 7	6 pcs	0.00 0.00	QC 7 - 10
				QC 7 - 13
				QC 7 - 14
				QC 7 - 15
				QC 7 - 17
				QC 7 - 18
				QC 7 - 19
				QC 7 - 2
				QC 7 - 28
				QC 7 - 3
				QC 7 - 30
				QC 7 - 34
				QC 7 - 36
				QC 7 - 37
				QC 7 - 41
				QC 7 - 47
				QC 7 - 48
				QC 7 - 51
				QC 7 - 58
				QC 7 - 59
				QC 7 - 60
				QC 7 - 9
				QC 7 - 68
				QC 7 - 50
				QC 7 - 67
				QC 7 - 40
				QC 7 - 24
				QC 7 - 43
				QC 7 - 61
				QC 7 - 81
				QC 7 - 76
				QC 7 - 79
				QC 7 - 83
				QC 7 - 82
170	Packaging 3-1 - Stock - B4B	6 pcs 8 pcs m/l	0.00 0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B
				Packaging 3 - 3 - B4B
				Packaging 3 - 4 - B4B
				Packaging 3 - 5 - B4B

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			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
180 QC 21 - SA	6 pcs	0.00 0.00	QC 21 - SA - 21	
			QC 21 - SA - 70	
			QC 21 - SA - 53	

APR 17 2020

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Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Form as per dwg)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.032	5052-H32 .032 Sheet (china mat'l only available)	4.7922 sf (.7987 ea)	100-Waterjet - Flow - 1	M135016 5101050

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M5052H32S.032	5	64	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 206702
Description: Cover		Part Number: D3641-1
Inspection Dwg: D3641	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	Ø.192	1		V-M-04	
0.191	+/-0.010	Ø.194	1		Taper	
0.37	+/-0.030	.37	1			
0.54	+/-0.030	.54	1			
0.69	+/-0.030	.69	1			
11.86	+/-0.030	11.86	1			
12.22	+/-0.030	12.22	1			
23.37	+/-0.030	23.37	1			
23.54	+/-0.030	23.54	1			
23.69	+/-0.030	23.69	1			
24.06	+/-0.030	24.06	1			
0.50	+/-0.030	.50	1			
4.28	+/-0.030	4.28	1			
4.78	+/-0.030	4.78	1			
0.032	+/-0.010	.031				

Measured by: [Signature]	Audited by: 9-88	Preliminary Approval:
Date: 20/03/22	Date: MAR 23 2020	Date:

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	
B	12.03.08	Dwg Rev updated	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

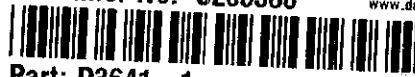
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S265568



Part: D3641-1

Job No: 206702

Serial No/Batch: S265568

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA

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Date: 03/22/20